



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D6103-003
Job Sheet 175911



5066454

Part No: D6103-003

Job Qty: 12 ea

Part Name: Round Billet, Aluminum



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 4/12/18

Job Tracking No:

Due Date: 5/8/18

Created By: Chantal Lavoie

Type: Stock

Description:

Note: DWG REV B

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Purchasing	12 pcs		5/8/18	0.00	0.00	Purchasing		DAS 28 2018
110	Packaging	12 pcs		5/8/18	0.00	0.00	Packaging2		DAS 28 2018
120	QC	12 pcs		5/8/18	0.00	0.00	QC6		DAS 28 2018
130	Packaging	12 pcs		5/8/18	0.00	0.00	Packaging3-2		DAS 21
140	QC21-SA	12 Ea		5/8/18	0.00	0.00	QC21		DAS 21 APR 30 2018

Part Op 100 - Issue P/O: 39599 a)Description: Alluminum round billet b) Ø3.500" x 12.500" long c) Tolerance on all Descriptions: dimensions are +0.030"/-0.000" d) Material: 7075-T7351 (QQ-A-225/9) Material certification required
110 - Ensure material certification is attached
130 - LOCATION: MAT043

X12

APR 13 2018

DAS
11
9-89

DAS
13
9-89

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6103-003P	Round Alum Billet	12 pcs (1 ea)	100-Purchasing	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	D6103-003P	12	0	0

Part Specifications

Specifications could not be found.

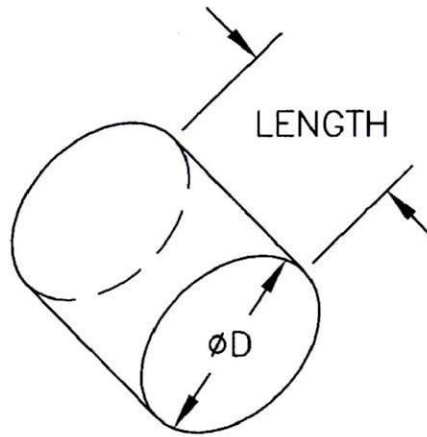
Plex 4/12/18 7:32 AM dart.lavoie.chantal



DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D6103	Rev. B SHEET 1 OF 1
DATE 06.01.31		TITLE ROUND BILLET, ALUMINUM	SCALE NTS
A	01.04.10	NEW ISSUE	
B	06.01.31	ADD D6103-003	

SPECIFICATION CONTROL DRAWING

RELEASED
06.02.07



PURCHASE MATERIAL ACCORDING TO THE FOLLOWING TABLE. SPECIFY ALLOY, DIAMETER x LENGTH (+0.030/-0.000) AS SHOWN.

TOLERANCE ON ALL DIMENSIONS IS +0.030/-0.000.

ALL DIMENSIONS ARE IN INCHES.

Part No.	Alloy	D (Diameter)	Length
D6103-001	7075-T6/T651 (QQ-A-200/11 OR QQ-A-225/9)	Ø3.250	12.50
D6103-003	7075-T7351 (QQ-A-225/9)	Ø3.500	12.50

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MATERIAL RECEIPT INSPECTION FORM

MATERIAL: 06103-003
 DATE: APR 28 2019

PO / BATCH NO.: 039599 / 5066433

MATERIAL CERT REC'D: yes
 QUANTITY RECEIVED: 11 Pcs
 QUANTITY INSPECTED: 4 Pcs
 QUANTITY REJECTED: 0

THICKNESS ORDERED: 3.500
 THICKNESS RECEIVED: 3.500
 SHEET SIZE ORDERED: N/A
 SHEET SIZE RECEIVED: N/A

DESCRIPTION	NCR (Check Y/N)		COMMENTS
SURFACE DAMAGE	Y	<u>N</u>	
CORRECT FINISH	<u>Y</u>	N	
CORROSION	Y	<u>N</u>	
CORRECT GRAIN DIRECTION	<u>Y</u>	N	
CORRECT MATERIAL PER M-DRAWING	<u>Y</u>	N	<u>QQA-225-9</u>
CORRECT THICKNESS	<u>Y</u>	N	
PHOTO REQUIRED	Y	<u>N</u>	
CORRECT REF # TO LINK CERT	<u>Y</u>	N	<u>Heat# MA 20171523</u>
CORRECT MATERIAL IDENTIFICATION	<u>Y</u>	N	
CORRECT M# ON THE MATERIAL	<u>Y</u>	N	
DOES THIS MATERIAL REQUIRE ENGINEERING SIGN OFF	Y	<u>N</u>	
DOES THIS REQUIRE AN EXTRUSION REPORT	Y	<u>N</u>	

CUT SAMPLE PIECE OF MATERIAL AND PREFORM A HARDNESS CHECK. RECORD RESULTS BELOW					
	HRC	HRB	DUR A	DUR D	WEBSTER
TYPE OF MATERIAL					
SIZE OF TEST SAMPLE					
HARDNESS / DUROMETER READING					

testers located in the Quality Office

QC 18 INSPECTION	ENGINEERING SIGNOFF (if required)
INSPECTED BY: <u>DAS 11</u> DATE: <u>9-89 APR 28 2018</u>	SIGNED OFF BY: _____ DATE: _____

Attach this inspection sheet with the corresponding material cert and remit to be scanned and received in

**Castle Metals®**

A. M. Castle & Co.

PACKING SLIP/
CERTIFICATE OF CONFORMANCE

Page 1 of 1

Shipment No:3580173

Ship From: A. M. CASTLE & CO. 2150 ARGENTIA ROAD MISSISSAUGA, ON L5N 2K7 CAN		Sold To: DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7 CA		Ship To: DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7 CAN		Deliver To: DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7 CA	
Date Shipped 26-APR-18	F.O.B. ORIGIN	Freight Terms Prepaid		Carrier MANITOULIN		BOL No 3580173-2	

Shipment Details	Final Destination Branch - TOR
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Order No	Line No	Item No	Description	
5108715	1	8808.MO	3.5000..RD.7075.T7351.ALUMINUM.CF.144.0000 CUT TO 12.5 IN (+ .1250/- .0000 IN) - BAND SAW CUTTING SPECIFICATIONS: AMS-QQ-A-225/9	
Purchase Order No		Part Number	Ordered Qty	Invoice Qty
39599		YOUR ITEM NUMBER: D6103-003	11.00 PCS	11.00 PCS

Details	ALL PAPERWORK MUST FOLLOW ORDER / CUSTOMER MUST RECEIVE AT TIME OF DELIVERY ALL MATERIAL MUST HAVE IDENTIFYING MARKINGS EX:HEAT #'S Email P/s and certs to: clavoie@dartaero.com END USER: DART AEROSPACE END USE: COMMERCIAL AIRCRAFT PARTS
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Delivery No. 121768977	Mill/Source	Heat Number 	Mech Id	PCS 11	Width (IN)	Length (IN)	Shipped Qty(LBS) 133.3791
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We hereby certify the material covered by this certification conforms in accordance with the above specifications and has been found to meet the applicable requirements for the material, including any specifications forming a part of the description. Test reports are on file subject to examination. All claims for defective material are waived unless made in writing to A.M. Castle & Co. within 60 days of the shipment. Material not to the correct size, or material cut by the customer cannot be returned for credit.				APR 26 2018			
Reviewed by Authorized Castle Metals Representative:				Date:	Name:		

Date Printed: 26-APR-2018 04:01:48 PM



Certified Inspection Report

10/02/17
07:20:05

Arconic Inc.
ARCONIC FORGINGS AND EXTRUSIONS
45 County Route 42, Massena, NY 13662



Customer Castle A M & Co	Customer P.O. No. 442171	Customer Part No. (8808)	Arconic Order No. MMC-C4469- -001	Govt. Contract No.
Ship To Castle A M & Co 3800 Enterprise Drive Janesville, WI 53546		We hereby certify that the material covered in this report has been inspected in accordance with, and has been found to meet the applicable requirements described herein, including any specifications forming a part of the description, or as previously agreed to with customer and that samples representative of the material met the composition limits and have the mechanical properties shown on the face of this sheet. Manufactured under a quality management system registered to ISO/AS9100. Melted and manufactured in the USA.		
		 Joseph M. Vierno, Quality Manager		

Date Shipped 09/30/17	Weight Shipped 1,972 lbs	Product CFRB-CF ROD	Specific Length BOL 000165182
Alloy - Temper 7075-T7351	Size 3.50000 IN	Shape DIA	Config 12 FT

Specifications:

AMS4124E
ASTMB211-12E1
Material conforms to T73 reqmts
Minimum mechanical properties to apply:
68 KSI Tensile Strength
56 KSI Yield Strength
10% Elongation
QQ-A-225/9E (Except Size)
AMS-QQ-A-225/9A (Except Size)
AMC A97075-11 R15

TEST REQUIREMENTS	Test U.T.S.	Test T.Y.S.	Test %Elong	Test Cond	Test	Test	Test	Test	Test	Test
Max:		67.9								
Min:	68.0	56.0	10.0	38.0						

Test Results	No. of Tests	Test U.T.S.	Test T.Y.S.	Test %Elong	Test Cond	Test	Test	Test	Test	Test	Test
Lot / Work Order MA20171523	1	Max: 73.7	63.2	14.0	41.2						
		Min: 73.7	63.2	14.0	41.2						

TEST ABBREVIATIONS

U.T.S. Ultimate Tensile Strength KSI
Cond Conductivity % IACS

T.Y.S. Tensile Yield Strength KSI .2% offset

%Elong Elongation % in 2"

Aluminum Association Chemical Composition Limits (in Weight %)

ALLOY	MAX	%SI	%FE	%CU	%MN	%MG	%CR	%ZN	%TI	%Others	%Others	%AL			
7075	MIN	0.40	0.50	2.0	0.30	2.9	0.28	6.1	0.20	0.05	0.15	Rem			
				1.2		2.1	0.18	5.1		Each	Total				

Actual Started Chemistry

LOT/WORK ORDER	MAX	%SI	%FE	%CU	%MN	%MG	%CR	%ZN	%TI	%OE	%OT	%AL			
MA20171523	MIN	0.05	0.13	1.6	0.00	2.5	0.19	5.8	0.02	LT 0.05	LT 0.15	Rem			
		0.05	0.13	1.6	0.00	2.5	0.19	5.8	0.02						

Certified Inspection Report

10/02/17
07:20:05

Arconic Inc.
ARCONIC FORGINGS AND EXTRUSIONS
45 County Route 42, Massena, NY 13662



Customer
Castle A M & Co

Customer P.O. No.
442171

Customer Part No.
(8808)

Arconic Order No.
MMC-C4469- -001

Govt. Contract No.

NOTES:

Ingot Source: Lafayette
Material compliant with DFARS 252.225-7001 (Buy American Act)
Mercury is not a normal contaminant in aluminum alloys and neither it nor any of its compounds are used in the manufacture of our product.
This alloy meets the requirements of EU 2011/65/EC (RoHS) and EU 2000/53/EC for lead, mercury, cadmium and hexavalent chromium.